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Modin

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(54) **APPARATUS FOR MAKING CONTOURED COMPOSITE STIFFENERS**

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B29C 70/34 (2006.01)

B29C 70/44 (2006.01)

(52) **U.S. Cl.**

CPC **B29C 70/543** (2013.01); **Y10T 156/1044** (2015.01); **Y10T 428/24** (2015.01); **B29C 70/541** (2013.01); **B29C 70/342** (2013.01); **B29C 70/443** (2013.01)

(58) **Field of Classification Search**

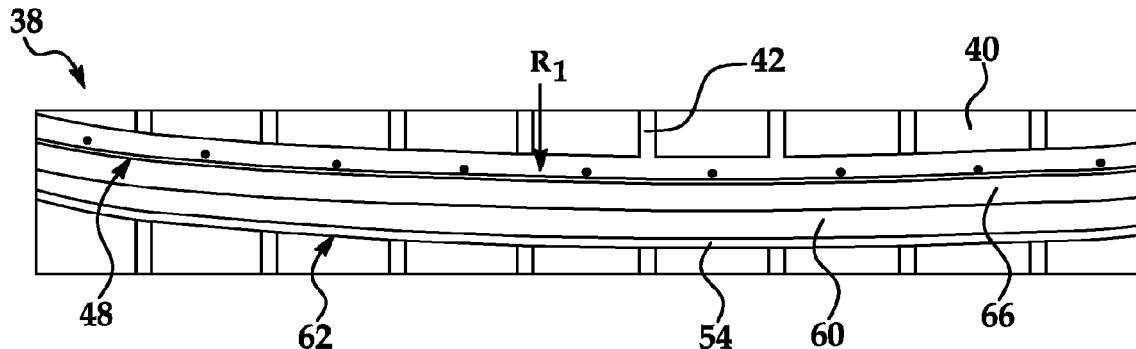
None

See application file for complete search history.

(57) **ABSTRACT**

A contoured composite part is made by assembling a preform charge, including aligning a plurality of plies along a preselected contour. The assembled aligned preform charge is then placed in a forming tool, where the charge is formed and cured.

9 Claims, 12 Drawing Sheets



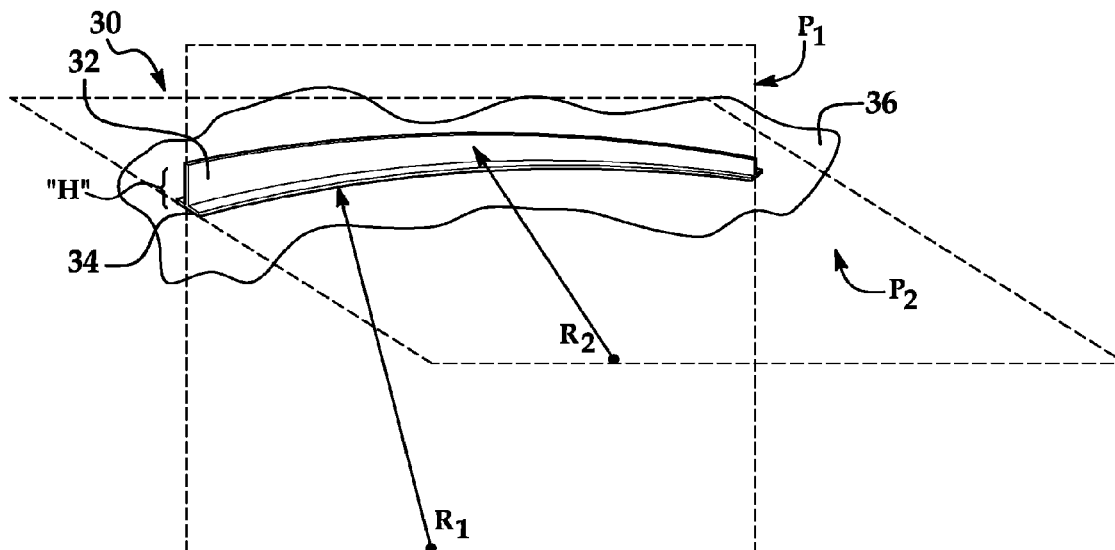


FIG. 1

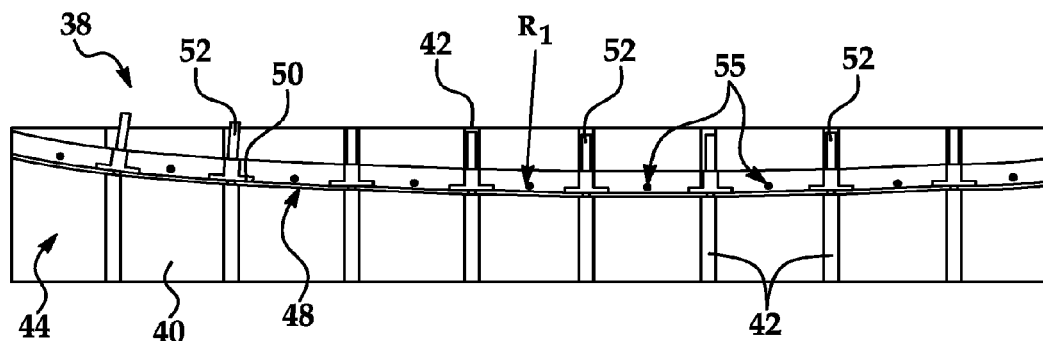


FIG. 3

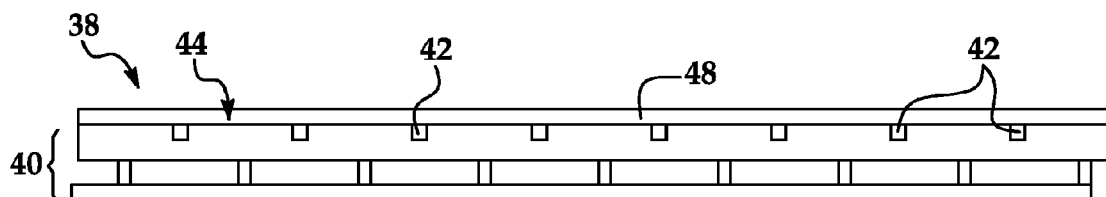


FIG. 4

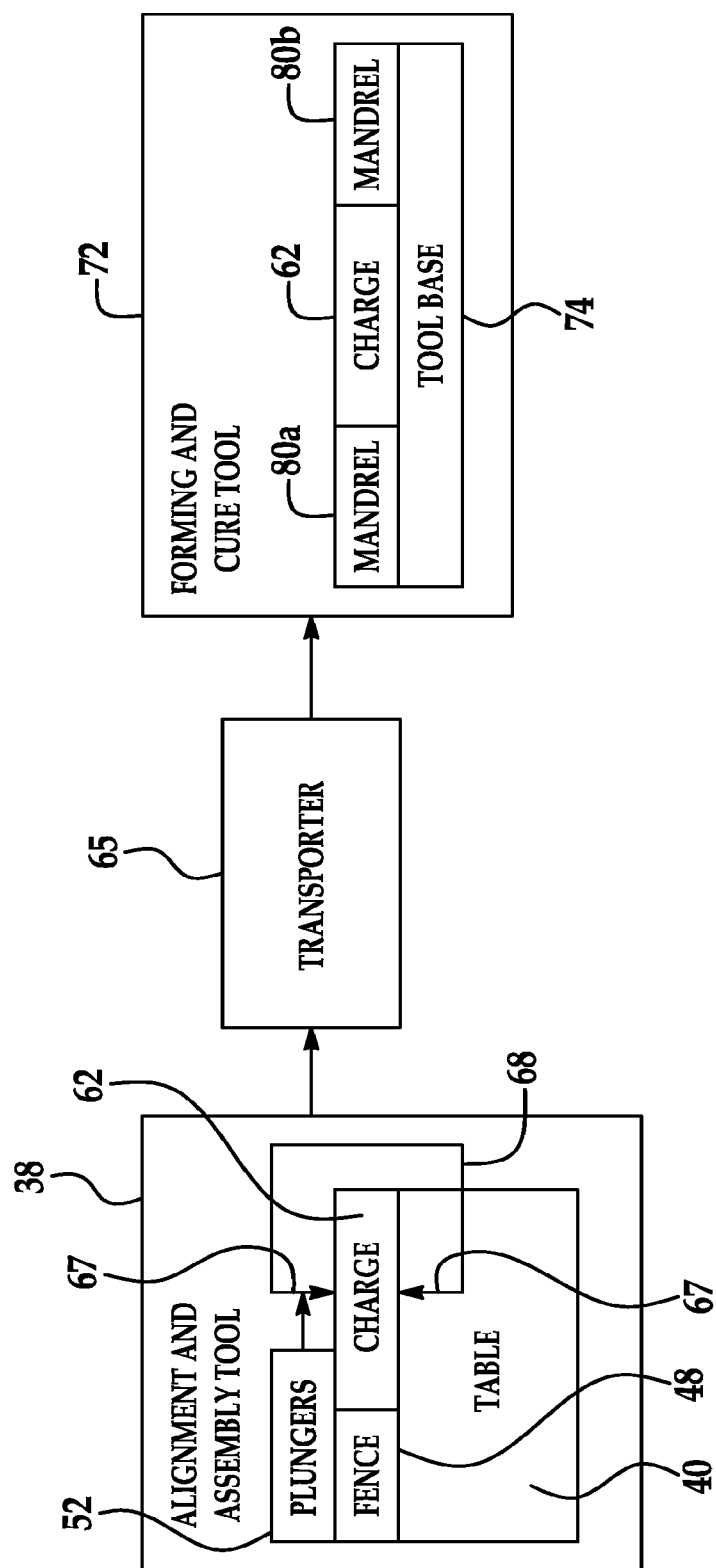


FIG. 2

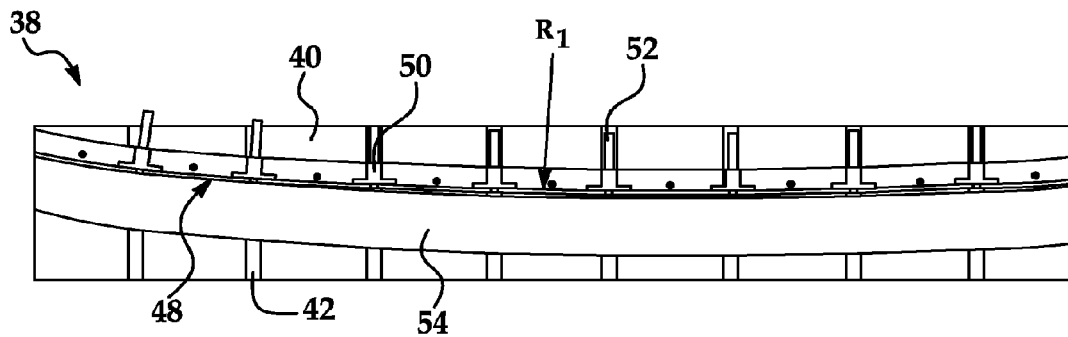


FIG. 5

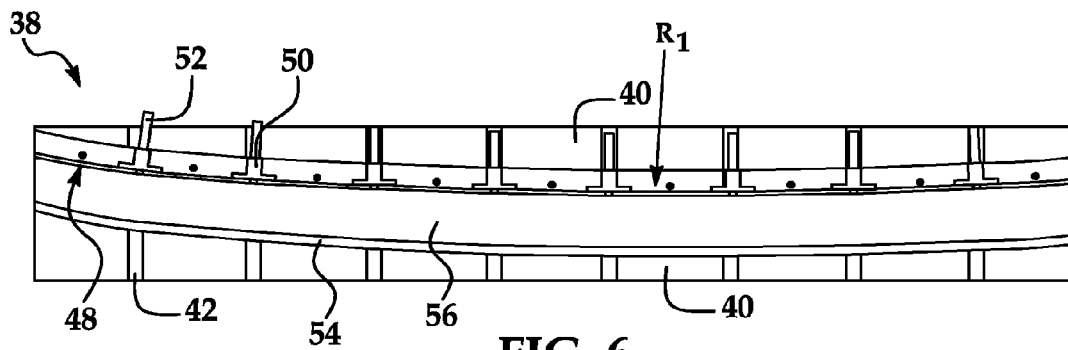


FIG. 6

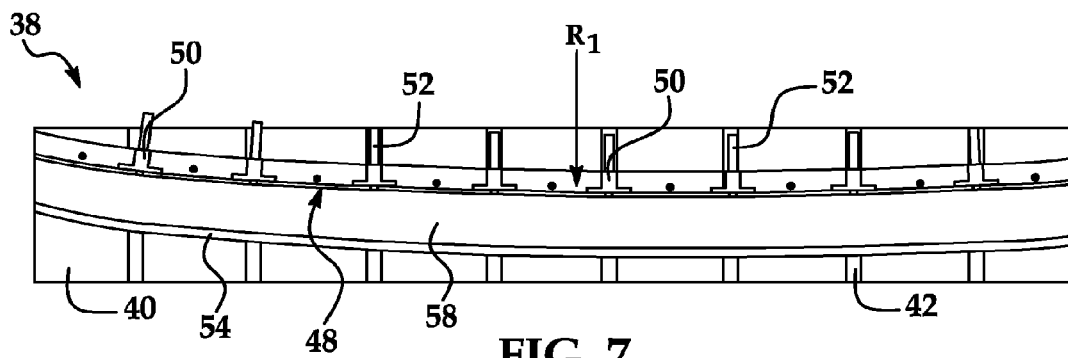


FIG. 7

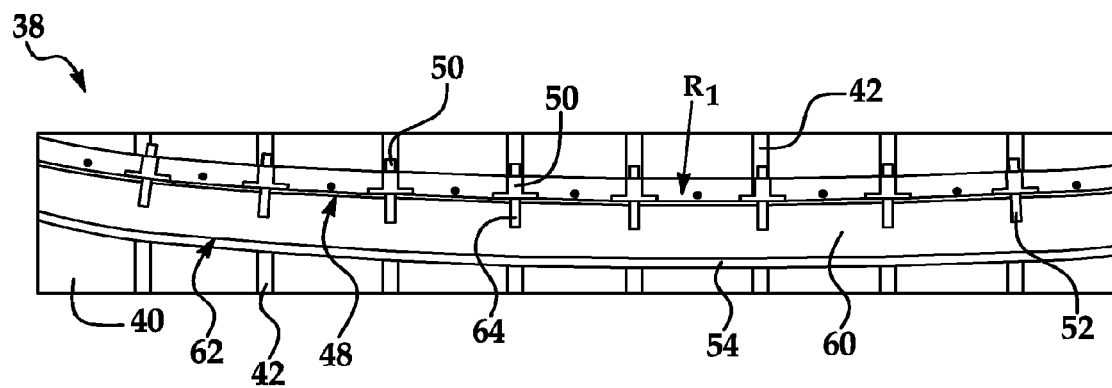


FIG. 8

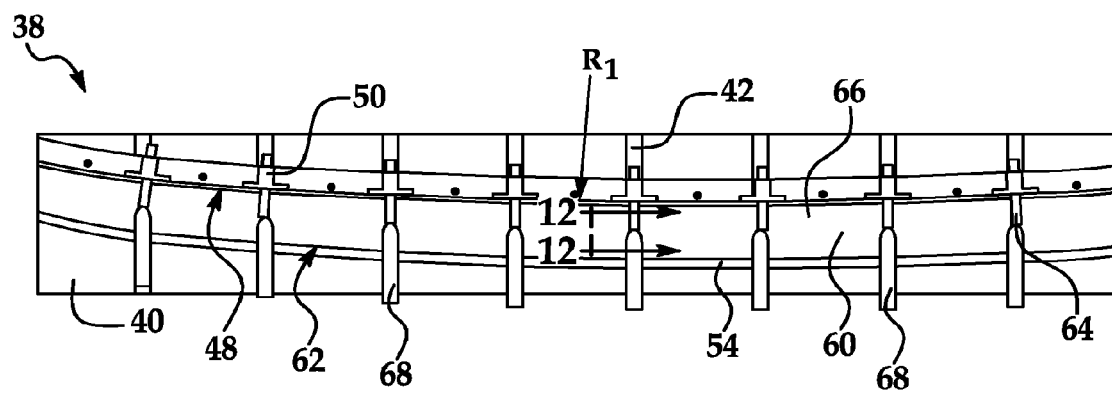


FIG. 9

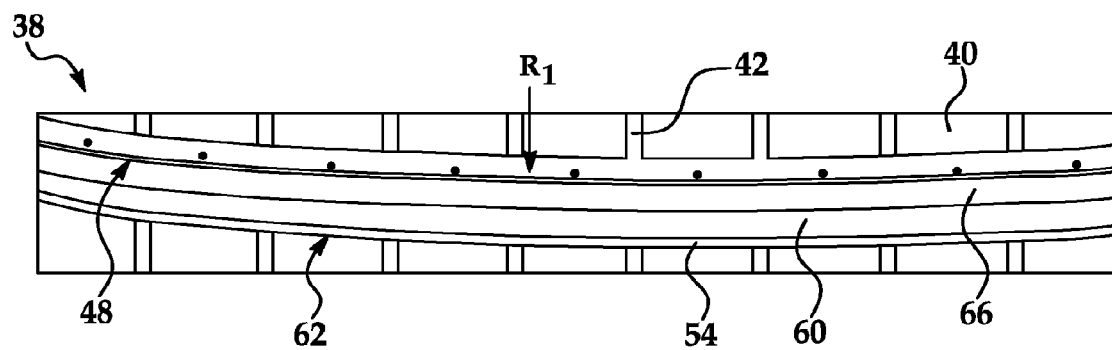
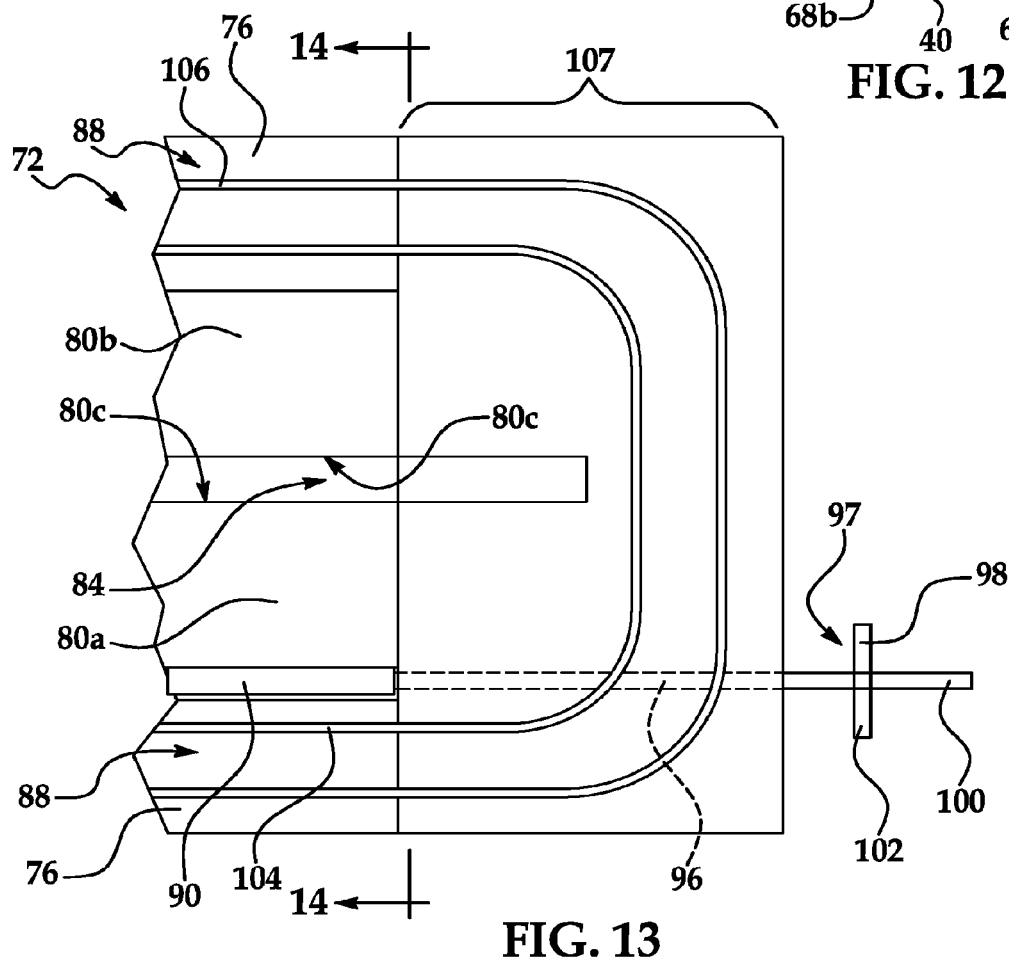
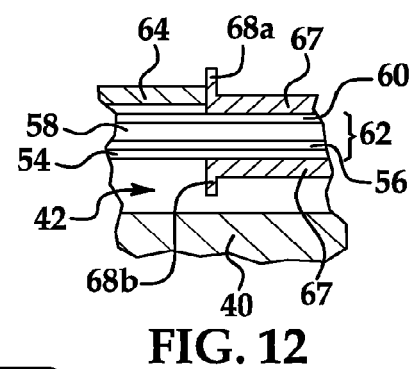
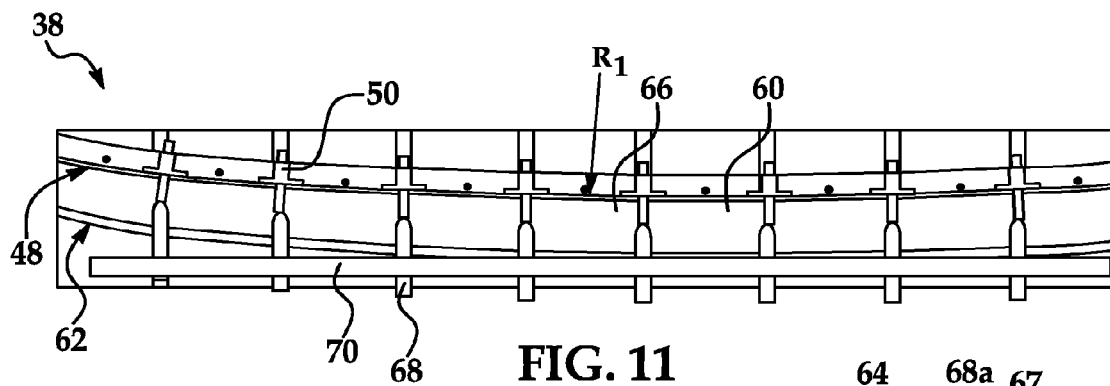


FIG. 10



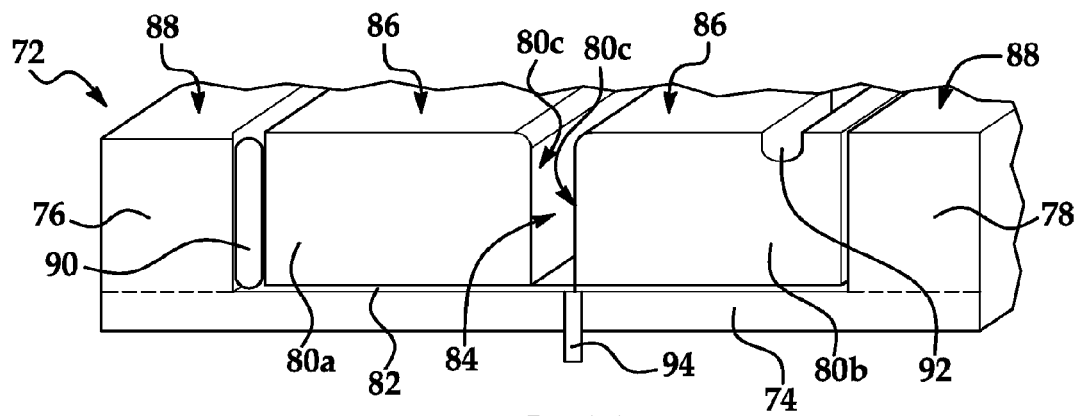


FIG. 14

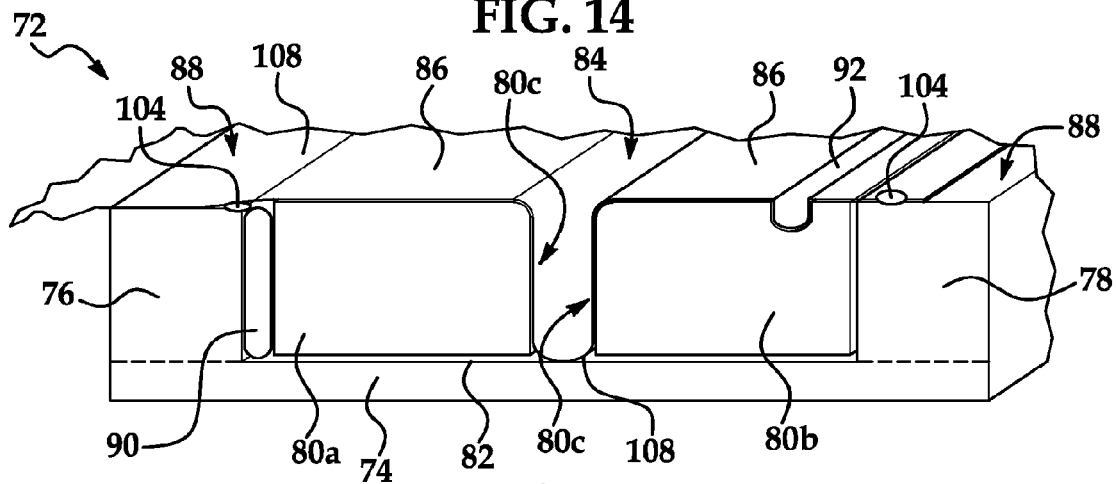


FIG. 15

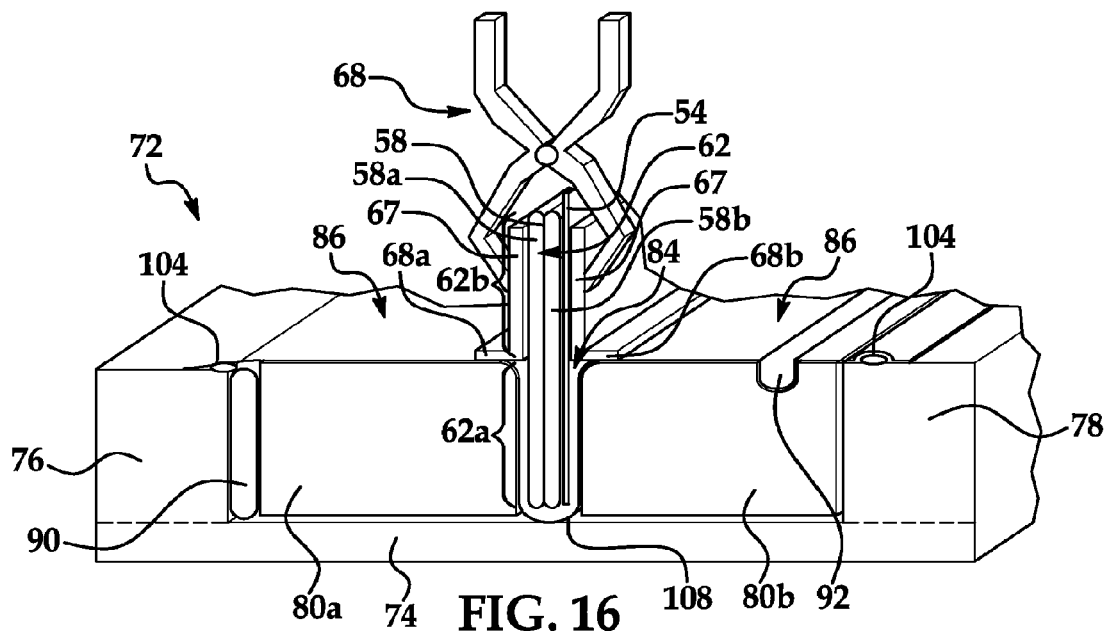


FIG. 16

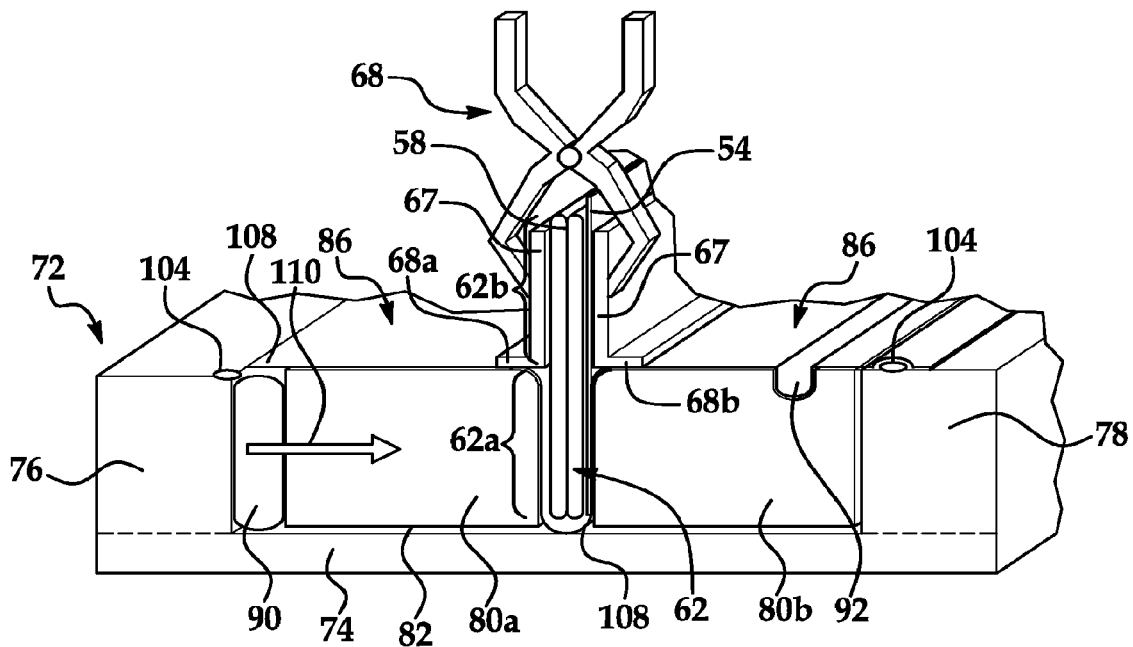


FIG. 17

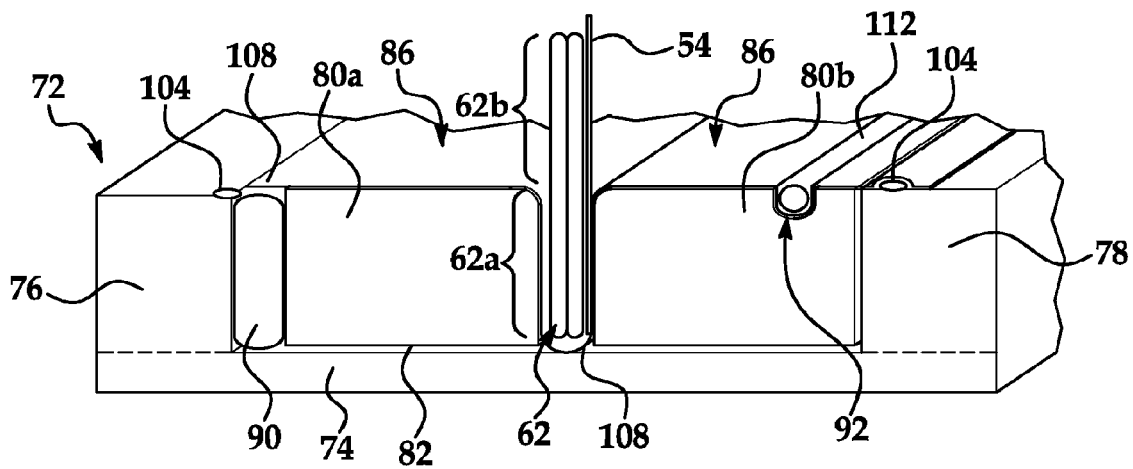


FIG. 18

FIG. 20

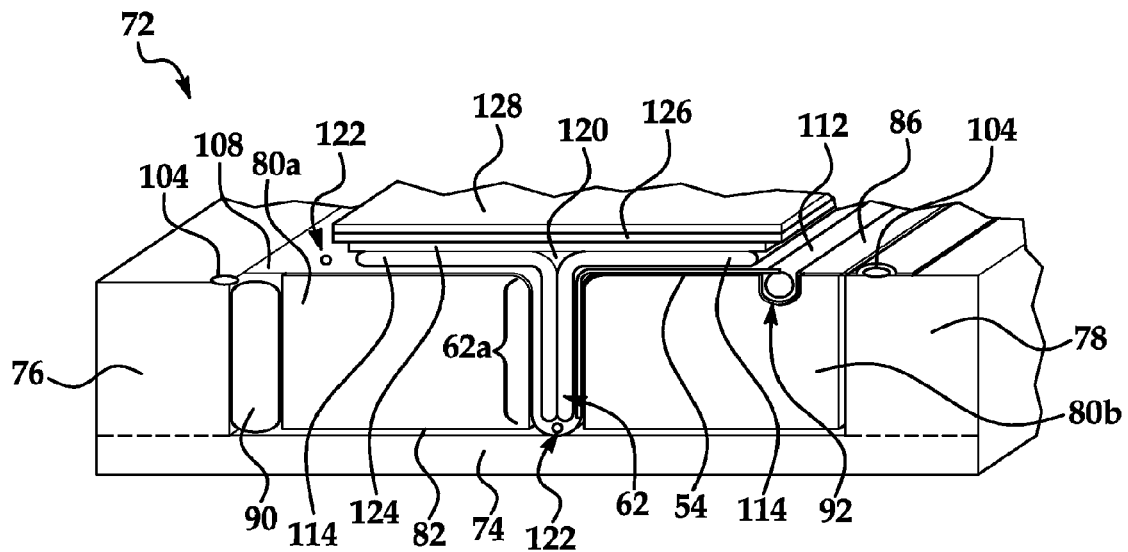


FIG. 21

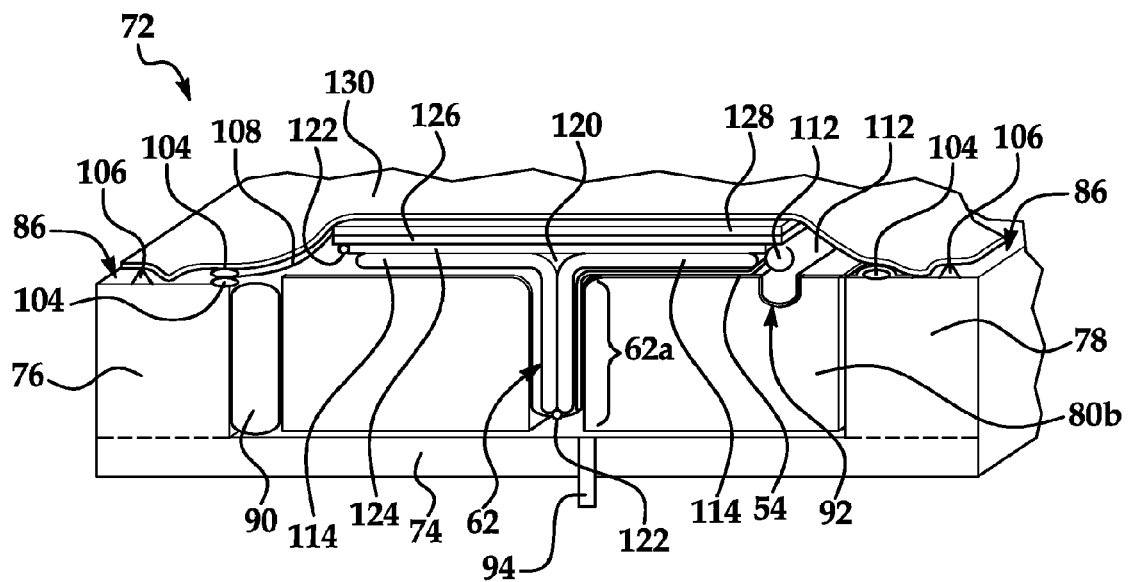
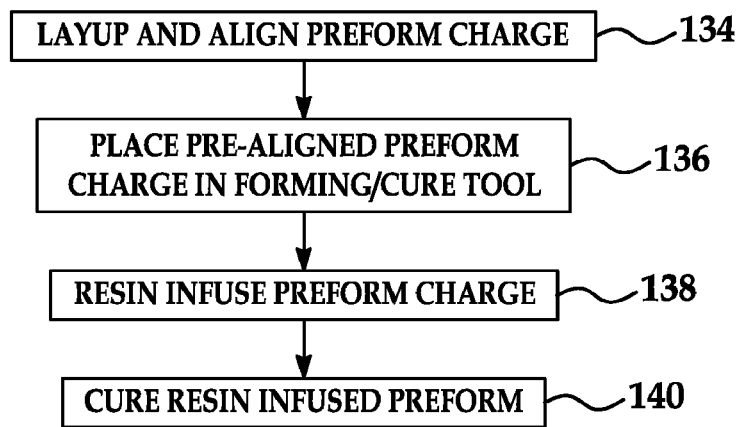
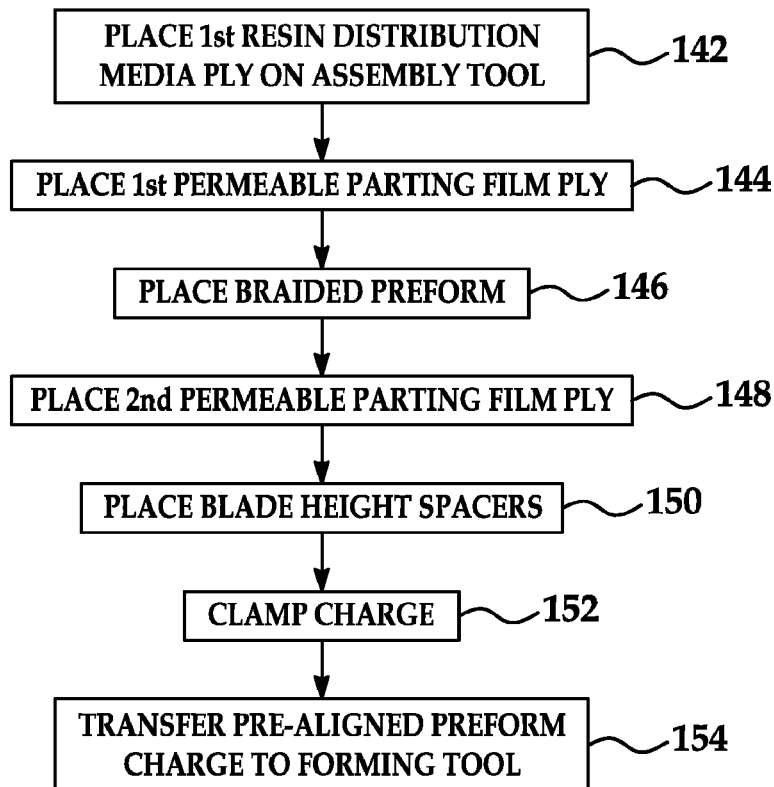


FIG. 22

**FIG. 23****FIG. 24**

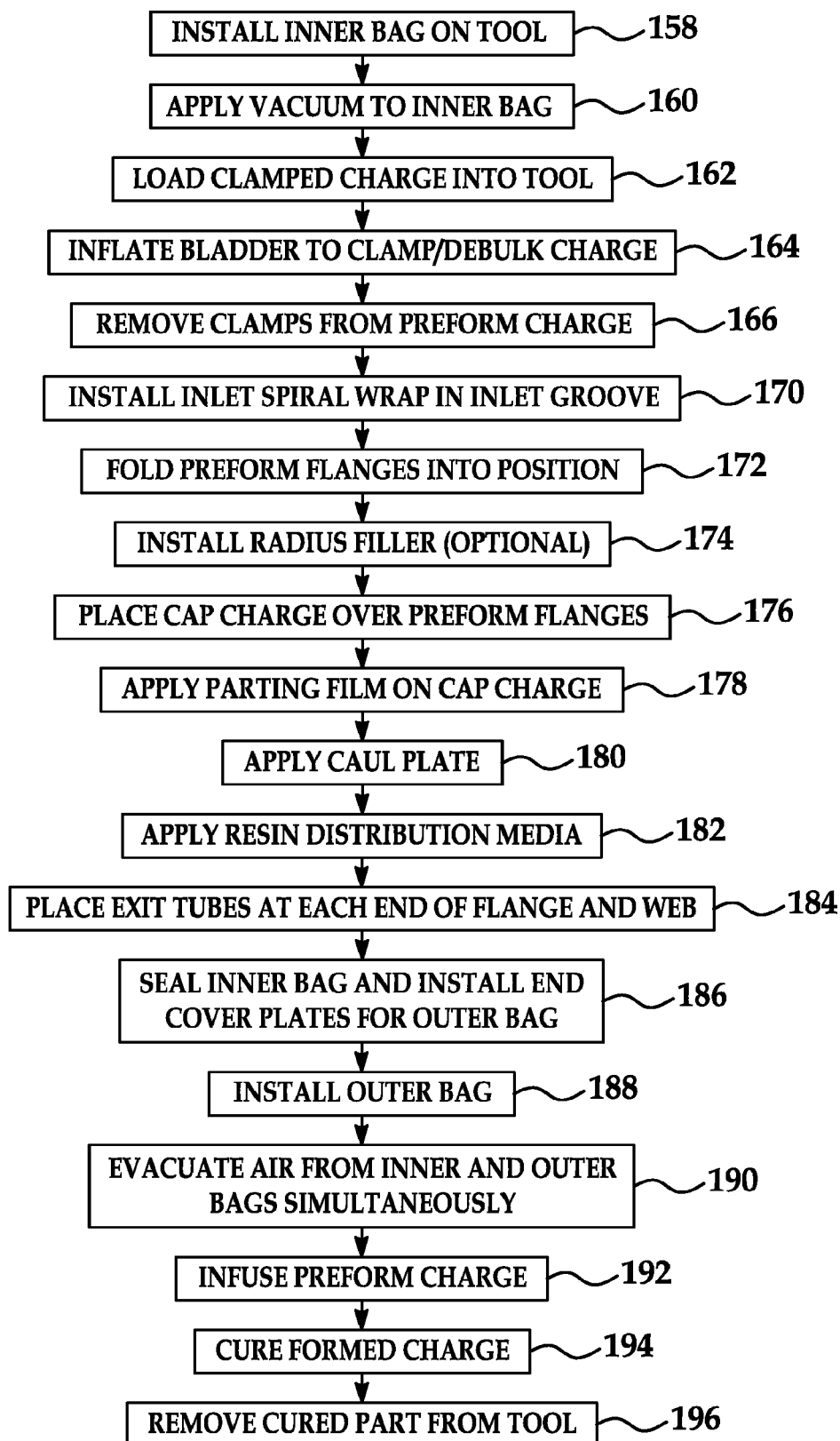


FIG. 25

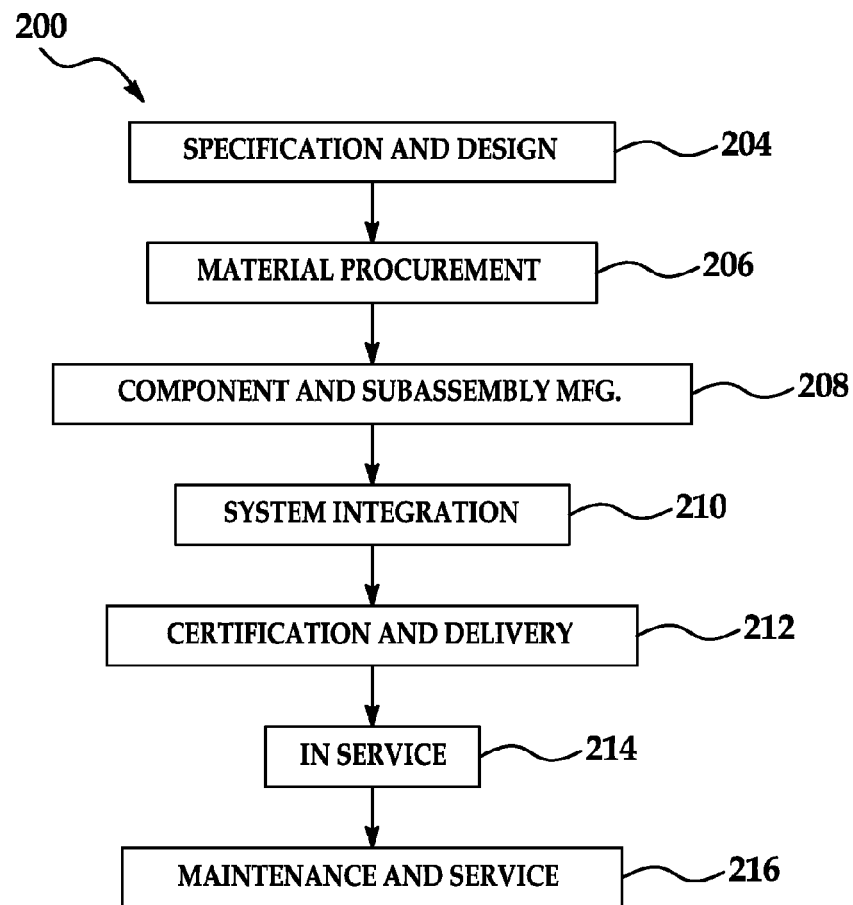


FIG. 26

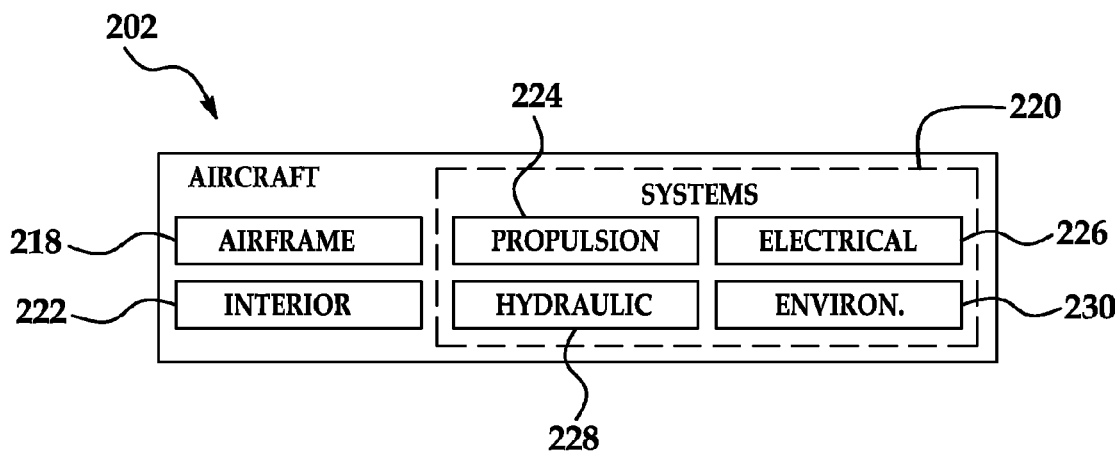


FIG. 27

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APPARATUS FOR MAKING CONTOURED COMPOSITE STIFFENERS

This application is a Divisional Application of application Ser. No. 13/079,945, filed Apr. 5, 2011.

TECHNICAL FIELD

This disclosure generally relates to the fabrication of composite parts, and deals more particularly with a method and apparatus for making contoured composite stiffeners.

BACKGROUND

Composite structural members such as stiffeners may be used in a variety of applications to increase the strength and/or rigidity of assemblies. For example, in the aircraft industry, structural stiffeners such as stringers may be used to strengthen a fuselage. The stringers may be contoured along their length in order to conform to curvatures in the fuselage. In some areas of the fuselage, the stringers may have compound contours along their lengths.

Composite stringers having compound contours of the type described above may be fabricated by laying up multiple plies of composite pre-preg over a tool having compound contours substantially matching those of the finished part. The layup may be formed to shape and cured using vacuum bag and autoclave processing. Fabrication techniques using pre-preg may have disadvantages in some applications. For example, in order to achieve the desired stringer contours, one or more of the pre-preg plies may require cutting, darting and/or splicing, which may add weight to the fuselage and/or cost.

Other techniques may be used to fabricate contoured stringers, such as resin infusion of dry fiber preforms. However, resin infusion may require the use of closed molds which need preparation and later cleanup after the part has been molded to shape. Moreover, alignment of the preform with resin distribution media and permeable parting films may be difficult without the use of stitching and/or tackifiers. Also, it may be difficult to control fiber angles in fiber preforms using known resin infusion techniques. Variations in fiber angles may result in undesired performance characteristics in the finished part.

Accordingly, there is a need for a method and apparatus for fabricating composite structural members having compound contours that reduce tool handling and which facilitate alignment of composite charges to better match tool contours. There is also a need for a method and apparatus as described above which may substantially eliminate the need for clean up of tooling following part molding, and which may be adapted for resin infusion processing using open molds.

SUMMARY

The disclosed embodiments provide a method and apparatus for fabricating composite structural members, such as stringers, having compound contours. The use of contour preform braiding with open bagged tooling provides uniform cure pressure for resin infusion curing to produce cured stringers with continuous fibers. In one embodiment, dual vacuum bags are used to provide pressure across the flanges of a stringer, and enabling them to be held in intimate contact with the mold surface while reducing the chance of bag leaks. Near net molding of stringers may be achieved without the need for stitching, tackifiers and tool handling. The use of an alignment tool for pre-aligning components of a preform fiber charge reduces the need for handling the preform, which may

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result in improved control over fiber angle and/or thickness of the finished part. The use of fiber preforms that are braided, including biaxial and triaxial braids, may allow the preform to better conform to and accommodate different and changing three dimensional contours and radii during layup.

The apparatus includes a preform charge assembly tool and a preform forming tool. A contoured, braided preform is assembled in the assembly tool with resin distribution media and permeable parting films. The assembly tool sets the desired contour with changing radii for the desired part. The assembled and pre-aligned preform charge is transferred from the assembly tool into an envelope vacuum bag held in a forming tool where a bladder-actuated mandrel clamps a web or blade portion of the preform, following which one or more flanges of the preform are folded to form stringer flanges. A radius filler and cap plies are added, as desired, the envelope vacuum bag is sealed, and a second vacuum bag is installed. The charge is then infused with resin. Following resin infusion and curing, the part is removed from the open mold and trimmed to the desired cross section and lengths.

In accordance with one disclosed embodiment, a method is provided of making a contoured composite part. The method comprises assembling a charge, including aligning a plurality of plies along a preselected contour and transferring aligned charge to a forming tool. The method further comprises forming the charge in the forming tool and curing the formed charge. Assembling the charge may include placing at least one fiber preform on an assembly tool, and aligning the plies may include using the assembly tool to align the fiber preform along the preselected contour. After being assembled on the assembly tool, a portion of the charge is clamped following which an unclamped portion of the charge is then inserted into the forming tool. The method may further comprise infusing the fiber preform with resin after the aligned charge has been transferred to the forming tool. The method may also comprise placing a first vacuum bag over the forming tool before the aligned charge is transferred to the forming tool, placing a second vacuum bag over at least a portion of the fiber preform contained within the first vacuum bag, and infusing the fiber preform with resin introduced into the first vacuum bag. The method may further comprise maintaining the alignment of the plies in the charge by clamping the plies together while in the assembly tool and keeping them clamped until they have been clamped in the forming tool.

According to another disclosed embodiment, a method is provided of making a composite structural member having a web and at least one flange. The method comprises assembling a multi-ply charge having at least one fiber reinforcement and clamping a first web portion of the charge in a tool. The method further comprises forming a second flange portion of the charge while the first web portion is clamped in the tool, and curing the formed charge. Assembling the charge may include aligning the plies relative to each other along a preselected contour, and clamping the aligned plies together.

According to a further embodiment, apparatus is provided for making a composite structural member having at least one contour. The apparatus comprises an assembly tool for assembling a plurality of plies forming a charge, and a forming tool for forming the structural member. The assembly tool includes a contoured alignment guide for aligning the plies along a contour and a clamping mechanism for clamping the pre-aligned plies together. The forming tool includes a pair of relatively moveable mandrels between which the assembled charge may be clamped. The forming tool includes a base, wherein the mandrels are relatively movable on the base toward and away from each other to clamp the charge therebetween. The mandrels include tool surfaces over which at

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least a portion of the clamped charge may be formed. The forming tool may further include an inflatable bladder for applying clamping pressure to one of the mandrels. The apparatus may also comprise the first vacuum bag covering the forming tool, and a second vacuum bag adapted to cover the formed charge, the web of which is clamped on the forming tool. Each of the mandrels includes a contoured clamping surface for forming a contour into the charge.

According to still another embodiment, apparatus is provided for making a composite member having a web with a compound contour and at least one flange. The apparatus comprises an assembly tool for assembling pre-aligning a charge along a first contour, and a forming tool. The forming tool includes a base and a pair of contoured mandrels on the base between which a web portion of the charge may be clamped and formed along the second contour. At least one of the mandrels includes a tool surface onto which a flange portion of the clamped charge may be formed.

BRIEF DESCRIPTION OF THE ILLUSTRATIONS

FIG. 1 is an illustration of a perspective view of a composite stringer having compound contours.

FIG. 2 is a functional block diagram of apparatus for fabricating the stringer shown in FIG. 1.

FIG. 3 is an illustration of a plan view of an assembly tool for assembling a composite charge used to make the stringer shown in FIG. 1.

FIG. 4 is an illustration of a side view of the assembly tool shown in FIG. 3.

FIG. 5 is an illustration similar to FIG. 3 showing resin distribution media having been placed on the assembly tool.

FIG. 6 is an illustration similar to FIG. 5 showing a permeable parting film having been placed over the resin distribution media.

FIG. 7 is an illustration similar to FIG. 6 showing a braided fiber preform having been placed over the permeable parting film.

FIG. 8 is a view similar to FIG. 7 but showing another permeable parting film having been placed over the fiber preform, and blade height spacers having been actuated.

FIG. 9 is an illustration similar to FIG. 8 but showing the preform charge clamps having been installed.

FIG. 10 is an illustration similar to FIG. 8 but showing the use of a continuous blade height spacer.

FIG. 11 is an illustration similar to FIG. 10 but showing a magnetic transfer bar having been attached to the clamps.

FIG. 12 is an illustration of a sectional view taken along the line 12-12 in FIG. 9.

FIG. 13 is an illustration of a plan view of one end of the forming tool prior to the installation of the pre-aligned charge and resin infusion components.

FIG. 14 is an illustration of a sectional view taken along the line 14-14 in FIG. 13.

FIG. 15 is an illustration similar to FIG. 14 but showing the placement of a first vacuum bag on the forming tool.

FIG. 16 is an illustration similar to FIG. 15 but showing the pre-aligned charge being placed in the forming tool, the parting films not shown for clarity.

FIG. 17 is an illustration similar to FIG. 16 but showing the bladder having been inflated to clamp the web portion of the charge.

FIG. 18 is an illustration similar to FIG. 17 but showing the charge clamps having been removed and a spiral resin inlet wrap having been installed in the tool.

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FIG. 19 is an illustration similar to FIG. 18 but showing the flange portion of the preform having been formed down onto the mandrels.

FIG. 20 is an illustration similar to FIG. 19 but showing a radius gap filler having been placed in the charge.

FIG. 21 is an illustration similar to FIG. 20, but showing additional components including a cap charge having been installed.

FIG. 22 is an illustration similar to FIG. 21 but showing an outer bag having been installed, sealed and evacuated.

FIG. 23 is an illustration of a flow diagram of a method of making a compound contoured composite member.

FIG. 24 is an illustration of a flow diagram showing additional steps of the method illustrated in FIG. 21.

FIG. 25 is an illustration of a flow diagram of another method of making a composite structural member having compound contours.

FIG. 26 is an illustration of a flow diagram of aircraft production and service methodology.

FIG. 27 is an illustration of a block diagram of an aircraft.

DETAILED DESCRIPTION

Referring first to FIG. 1, the disclosed embodiments broadly relate to a method and apparatus for making a curved composite part, such as, for example and without limitation, a compound contoured composite stringer 30. In the illustrated embodiment, the stringer 30 is contoured according to radii R_1 , R_2 , which respectively oriented in orthogonal planes P_1 , P_2 however other contouring geometries are possible, and the stringer 30 may be contoured, or partially contoured along only a portion of its length. In other embodiments, the stringer 30 may have only a single contour along its length. In the illustrated embodiment shown in FIG. 1, R_1 and R_2 form planar arcs that are substantially constant, however R_1 , and/or R_2 may be vary axially and or laterally such that the stringer 30 includes one or more twists along its length. The stringer 30, sometimes referred to as a "blade stringer", includes a web portion 32 and a flange portion 34 which may be joined by any suitable means to a contoured skin 36. The web portion 32, sometimes also referred herein as a "blade", has a height "H". While a blade stringer 30 is illustrated in the exemplary embodiment, the disclosed method and apparatus may be employed to fabricate a variety of other elongate structural members having one or more contours along their length. Also, the disclosed method and apparatus may be employed to fabricate elongate structural members having any of a variety of cross sectional shapes, including without limitation, "C", "J", and "I" shapes, to name only a few.

FIG. 2 illustrates the primary components of the apparatus for fabricating a composite part such as the stringer 30 shown in FIG. 1. The apparatus broadly comprises an alignment and assembly tool 38 (hereinafter referred to as an assembly tool 38, for simplicity of description), and a forming and cure tool 72 (hereinafter referred to as a forming tool 72, also for simplicity of description). The assembly tool 38 includes a table 40 for supporting the charge 62, and a curved fence 48 on the table 40 that is used to align the components 54, 56, 58, 60 (see FIG. 12) of the charge 62. Once aligned, the components 54, 56, 58, 60 (FIG. 12) of the charge 62 are held between the jaws 67 of a plurality of clamps 68. The positions of the clamps 68 on the charge 62 determine the blade height "H" of the stringer 30 shown in FIG. 1 and are by the amount of extension of plungers 52 which engage at least one of the jaws 67 of the clamps 68.

After the charge 62 has been clamped by the clamps 68, a suitable transporter 65 such as a robot (not shown) may be

used to transport the clamped charge 62 to the forming tool 72. The forming tool 72 broadly comprises a pair of mandrels 80a, 80b slideable on a tool base 74. The charge 62 is held between the mandrels 80a, 80b during the forming process, described in more detail below, while the charge is formed onto the mandrel 80a, 80b.

FIGS. 3-12 illustrates additional details of the assembly tool 38 as well as sequential steps for aligning and assembling the components 54, 56, 58, 60 (FIG. 12) the charge 62. Referring particularly to FIGS. 3 and 4, the assembly tool 38 comprises a vacuum table 40 having a substantially flat charge supporting surface 44, which includes a plurality of generally parallel, transversely extending slots 42. A plurality of double acting cylinders are mounted on the table 40 and respectively include axially extendable, elongate plungers 52 disposed above the vacuum table surface 44 which act as blade depth spacers. In other embodiments (not shown), plungers 52 may be provided both above and below the table surface 44. The cylinders 50 may be air/gas, hydraulically or electrically actuated. An alignment fence 48 having a desired contour or changing radius R_1 substantially corresponding to the radius R_1 shown in FIG. 1, is secured to the table surface 44 by fasteners 55. In other embodiments, the contour R_1 of the fence 48 may be changeable through the use of numeric control devices, pins, etc.

As will be discussed below in more detail, the assembly tool 38 functions to pre-align the components 54, 56, 58, 60 (FIG. 12) of a charge 62 (FIG. 2), sometimes also referred to herein as a fiber preform assembly, such that the components 54, 56, 58, 60 of the charge 62 are aligned relative to each other, and are also aligned along the contour R_1 of the alignment fence 48. As used herein, the term "charge" is intended to include both fiber preforms or parts that may be dry or partially infused, and prepregs. In the illustrated embodiments discussed below, the charge 62 comprises a dry fiber preform 58 (FIG. 7), however, principals of the disclosed method and apparatus may be employed to fabricate composite structures using prepregs.

Referring to FIG. 5, in use, a charge 62 (FIG. 2) is stacked up by first placing a resin distribution media 54 on the table surface 44, aligned along the contoured fence 48. Next, as shown in FIG. 6, a ply of a permeable parting film 56 is placed on the distribution media 54, also aligned along the contour of the fence 48.

Referring to FIG. 7, next, a fiber preform 58 which may comprise one or more tubular or sock-like braided fiber preform 58a, 58b (see FIG. 16), is placed over the permeable parting film 56 shown in FIG. 6, also aligned along the contoured fence 48. Then, as shown in FIG. 8, a second ply of a permeable parting film 60 is placed on the fiber preform 58 and is aligned along the fence 48, thereby forming a complete charge or preform assembly 62 comprising two plies of permeable parting film 56, 60, resin distribution media 54 and the braided fiber preform 58 (see FIG. 12). The use of a braided fiber preform 58 may allow automated fabrication of an engineered preform that allows compound curvature of the stringer 30 and facilitates layup. The braided fiber preform 58 may comprise crimped or non-crimped fibers, and may comprise a biaxial braid of three or more fibers or a triaxial braid in order to provide the stringer 30 (FIG. 1) with additional strength. Also, fiber preforms fabricated by processes other than braiding may be possible.

The charge 62 having been sequentially formed and pre-aligned along the fence 48, and the blade height "H" shown in FIG. 1 having been pre-established by the axial positions of the plungers 64 (FIG. 8), a plurality of clamps 68 (FIG. 8), or other suitable clamping mechanisms, are placed in and

guided along the slots 42 in the table 40 until they are brought into abutment with the plungers 64, as best seen in FIGS. 9 and 12.

Each of the clamps 68 may be a scissor-action or other type of "C" clamp, such as that shown in FIGS. 12, 14 and 16, having a pair of opposing jaws 67 with lateral flanges 68a, 68b respectively. As shown in FIG. 12, one of the jaws 67 of each clamp 68 is received within and slideable along one of the slots 42 beneath the charge 62, while the other jaw 67 of the clamp 68 extends over the top of the charge 62. The clamps 68 are positioned around the charge 62 and passed through the slots 42 in the table 40 shown in FIGS. 4-12 until the lateral flange 68a of one of the jaws 67 (see FIG. 12) engages the end of the plunger 64 above the charge 62. In alternate embodiments (not shown in the Figures) plungers 64 may be provided both above and below the table surface 44 (FIG. 4), in which case both lateral flanges 68a, 68b will engage and stop against one of the plungers 64. The plungers 64 therefore act as stops which determine the position of the clamps 68 on the charge 62, and particularly the location of the lateral flanges 68a, 68b, on the charge 62. Effectively, the blade height "H" established by the axial positions of the plungers 64 is transferred to the clamps 68, since the lateral flanges 68a, 68b on the jaws 67 of the clamps 68 abut the plungers 64.

In an alternate embodiment shown in FIG. 10, the blade height "H" may be established by placing a continuous block or plate 66 on each side of the charge 62 shown in FIG. 12. The clamps 68 (FIGS. 9 and 12) are then installed on the charge 62, abutting the plate 66 to establish the blade height "H". Thus, the blade height "H" may be established by using discrete, spaced apart elements (e.g. plungers 64), or by a continuous element (e.g. the plate 66).

In an optional embodiment, shown in FIG. 11, a magnetic transfer bar 70 may be attached to the clamps 68 in order to hold and stabilize the clamped charge 62 while it is being transferred to the forming tool 72 shown in FIGS. 11-20 by the transporter 65 (FIG. 2). A variety of other means of stabilizing the clamps 68 and thus the preform assembly 62 during transfer to the forming tool 72 may be employed, such as without limitation, grips, plates, ball-lock pins, rods and fixtures (all not shown).

Referring now to FIGS. 13 and 14, in one embodiment, the forming tool 72 may be employed to form, infuse and cure the preform assembly 62 (FIG. 12) described above. Infusion may be performed using a controlled atmospheric pressure resin infusion process in order to achieve cost effective manufacture of the stringers 30. One such suitable infusion process is described in U.S. Pat. No. 7,334,782 issued Feb. 26, 2008, the entire disclosure of which is incorporated by reference herein, however, other infusion processes may be possible.

The forming tool 72 broadly comprises a pair of mandrels 80a, 80b at least one of which is slideable on a low friction slip plate 82 (FIG. 14) that is supported on a tool base 74. The tool base 74 may be contoured along its length to substantially match the first contour R_1 (FIG. 1) of the stringer 30. The mandrels 80a, 80b have opposing tool faces 80c that are contoured along their lengths to substantially match the second contour R_2 of the stringer (FIG. 1). A pair of curve blocks 76, 78 are mounted on opposite sides of and sealed to the tool base 74 having a curvature generally matching the first contour R_1 (FIG. 1) of the stringer 30. Alternatively, curve blocks 76, 78 and tool base 74 may be one contiguous piece either by bonding, welding or machining a pocket from a single block of material. An inflatable bladder 90 is sandwiched between curve blocks 76 and mandrel 80a.

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In one embodiment, the mandrels **80a**, **80b** may each comprise a single piece, while in other embodiments, they may each be segmented along their length (not shown). The opposing tool faces **80c** of the mandrels **80a**, **80b** are laterally spaced apart from each other to form a tapered slot **84** therebetween. Each of the mandrels **80a**, **80b** further includes an upper, generally flat tool surface **86**. Mandrel **80b** is provided with a longitudinally extending resin inlet groove **92** therein for purposes discussed later. The tool base **74** may include a pneumatic fitting **94** adapted to be coupled with an outer bag air regulator (not shown).

Referring particularly to FIG. **13**, the end **107** of the tool **72** includes an internal pneumatic passageway **96** that couples the inflatable bladder **90** through a valve **97** to a vacuum **98**, vent **100** and compressed air **102** for controlling inflation and deflation of the bladder **90**. The location of later discussed inner and outer bag seals are respectively indicated at **104** and **106**.

FIG. **15** illustrates the forming tool **72** after an inner IML (inner mold line) bag **108**, also referred to herein as a first bag **108**, has been placed over and sealed to the tool **72** by an inner bag seals **104**. The inner first bag **108** is wider than the tool **72** such that a portion **109** of the bag **108** drapes down over an edge **111** of the forming **72**. As will be discussed later, inner bag portion **109** may be subsequently be folded back over the pre-form assembly **62** (not shown in FIG. **15**) and sealed to the tool **72**. Following placement on the tool **72**, a slight vacuum may be applied through fitting **94** (FIG. **22**) to the inner bag **108** in order to draw it down against the tool block surfaces **86** and into the slot **84** between the mandrels **80a**, **80b**. For clarity of the description below, not all areas of the inner first bag **108** are shown in FIGS. **14-19**.

Following installation of the inner first vacuum bag **108**, the pre-aligned preform assembly **62** is transferred from the assembly tool **38** (FIGS. **2-12**) to the forming tool **72** by the transporter **65** (see FIG. **2**). Referring to FIG. **16**, with the bladder **90** deflated and the mandrels **80a**, **80b** spread to form the open slot **84**, the clamped preform assembly **62** is inserted into the slot **84** between the opposing mandrel surfaces **80c**. For sake of clarity, the parting films **56**, **60** are not shown in either FIG. **16**, or **17** discussed below. The position of the clamps **68** on the preform assembly **62**, and particularly the location of the flanges **68a**, **68b**, define a web portion **62a** corresponding to the web portion **32** (FIG. **1**) of the stinger **30**, and a flange portion **62b** corresponding to the flange portion **34** of the stinger **30**. The flanges **68a**, **68b** are brought into engagement with the upper mandrel surfaces **86** as the preform assembly **62** is inserted into the slot **84**, thereby establishing the web height "H" shown in FIG. **1**.

FIG. **17** illustrates the next step in the assembly process, in which the bladder **90** is inflated to apply a force in the direction shown by arrow **110**, causing the mandrel **80a** to slide toward the mandrel **80b**, thereby clamping the web portion **62a** of the preform assembly **62** between the two mandrels **80a** and **80b**, while the flange portion **62b** of the preform assembly **62** remains held by the clamps **68**. It should be noted here that while a bladder **90** has been shown in the illustrated embodiment, other means of drawing the mandrels **80a**, **80b** together to clamp the assembly **62** may be possible, including but not limited to motors, screws, mechanical mechanisms (all not shown).

Referring now to FIG. **18**, the next step in the assembly process involves removal of the clamps **68** from the preform assembly **62**, after the web portion **62a** of the assembly **62** has been clamped between the mandrels **80a**, **80b**, leaving the flange portion **62b** of the assembly **62** exposed above the

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upper mandrel surfaces **86**. A resin inlet spiral wrap **112** is then placed in the groove **92** and is coupled with a suitable source of resin (not shown).

Referring to FIG. **19**, the next step in the assembly process involves folding the flange portion **62b** of the preform assembly **62** in the directions shown by the arrows **116**, down onto the upper mandrel surfaces **86**. This folding process also results in folding of the resin distribution media **54** over and into contact with the resin inlet spiral wrap **112** so that resin introduced through the spiral wrap **112** flows into the resin distribution media **54** during the subsequent infusion process. During this folding process, any fiber angle distortion of the fiber preform **58** is minimized or substantially eliminated as a result of the web portion **62a** having been previously clamped and held in place while the flange portion **62b** is being formed into flanges **114**.

Clamping of the preform assembly **62** also assists in debulking the web portion **62a** of the preform **58**. Folding of the flanges **114** onto the upper mandrel surfaces **86** may result in a radius gap **118** being formed at the intersection of flanges **114** and web portion **62a**. In this event, as shown in FIG. **20**, a suitable radius gap filler **120** may be inserted into the gap **118**. In the case of an "L" shaped part, a non-stick re-usable radius filler may be used.

Attention is now directed to FIG. **21** which illustrates the forming tool **72** at a later, optional stage of the assembly process in those applications where the stringer **30** (FIG. **1**) includes a cap **124** used to cover and reinforce the flange **34** (FIG. **1**). In this stage, a fiber cap preform **124**, a permeable parting film (not shown), a permeable caul plate **126** and resin distribution media **128** are sequentially stacked on top of the flanges **114**. Resin exit tubes **122** are placed along the edge of the flange **114** and at the ends of the web portion **62a** of the preform assembly **62**. In lieu of placing two end exit tubes for the web portion of **62a**, a continuous resin exit tube (not shown) may be placed into the inner bag prior to insertion of the preform charge. The exit tubes **122** allow complete evacuation of air and gases as well as excess resin to bleed away from the infused preform **58**, so that substantially uniform pressure is applied to the preform **58** during curing.

Attention is now directed to FIG. **22** which illustrates the forming tool **72** in a further stage of the assembly process. The bag portion **109** has been folded back over the tool and sealed by the seals **104**. Then, an outer second vacuum bag **130** is placed over the tool **72** covering the inner bag **108** and the preform assembly **62**. The outer second vacuum bag **130** is then sealed to the forming tool **72** including the upper surfaces **86** of the curved blocks **76**, **78** by outer bag seal **106**. Fitting **94** may then be coupled with a suitable outer bag regulator (not shown) which regulates the vacuum applied to the outer bag **130**. Air is then evacuated from the inner and outer bags **108**, **130** substantially simultaneously. In one exemplary embodiment, the inner bag **108** is drawn to a slightly higher vacuum than the outer bag **130**. For example, and without limitation, in one application, the inner bag **108** may be drawn to a vacuum of approximately 30 Hg while the outer bag **130** is drawn to approximately 25 Hg.

Following forming and compaction, the pressure applied to the preform assembly **62** may be adjusted, as required. In one example, the cure pressure applied to the web portion **62a** (FIG. **22**) is established by the pressure applied to the mandrel **80a** by the bladder **90**. The cure pressure applied to the flanges **114** is established by the vacuum level in the inner bag **108** and the pressure holding the flanges **114** on the mandrel surfaces **86** established by the vacuum level in the outer bag **130**. After curing, the outer bag **130** is removed, following which the bladder **90** is deflated. Deflation of the bladder **90**

allows the mandrels **80a**, **80b** to move apart, thereby unclamping the inner bag **108** and all of its contents, including the resin infused preform **58** which has become the cured stringer **30** and all associated disposable materials to be removed from the forming tool **72**.

Attention is now directed to FIG. **23** which illustrates a method of making a contoured composite part according to the disclosed embodiments previously discussed. Beginning at **134**, a charge which may comprise a fiber preform assembly **62** is stacked up and aligned, following which, at **136**, the pre-aligned preform assembly **62** is placed in a forming tool **72**. Next, at **138**, the preform assembly **62** is infused with resin following which, at **140**, the resin infused preform assembly **62** is cured.

FIG. **24** illustrates another embodiment of a method for making a composite structural member according to the disclosed embodiments. Beginning at **142**, a resin distribution media ply **54** is placed on an assembly tool **38** following which at **144**, a first permeable parting film ply **56** is placed over the resin distribution media ply **54**. At **146**, a suitable braided fiber preform **58** is placed over the first permeable parting film **56** ply following which a second permeable parting film ply **60** is placed over the preform **58**, as shown at **148**. At **150**, one or more blade height spacers **64** or **66** are placed on the charge, and at **152**, the stacked assembly **62** is clamped together to maintain ply alignment. Next, at **156**, the pre-aligned preform assembly **62** is transferred to a forming tool **72** where it is resin infused and cured.

FIG. **25** illustrates additional details of a method of making a contoured composite structural member **30** having a web **32** and at least one flange **34**. Beginning at **158**, an inner vacuum bag **108** is installed on a forming tool **72** following which, at **162** a vacuum is applied to the inner bag **108** to draw it down onto the forming tool **72**. At **161** an exit spiral wrap **122** is placed in the bottom of the vacuum bag groove. Next, at **162**, a clamped preform assembly or charge **62** is loaded onto the forming tool **72**, and at **164**, a bladder **90** is inflated which clamps and debulks the preform assembly **62**. At **166**, the assembly **62** is unclamped, and at **170**, an inlet spiral wrap **112** is installed in an resin inlet groove **92** in the tool **72** as shown at **170**.

Next, at **172**, flanges **114** of the preform assembly **62** are folded into position, following which at **174**, a radius filler **120** may be optionally installed into a gap **118** which may be present between the flanges **114**. At **176**, a cap charge **124** is applied over the preform flanges **114**. At **178**, a permeable parting film **124** is applied over the cap charge **124** and at **180**, a permeable caul plate **126** is applied over the permeable parting film. At **182**, a resin distribution media **128** applied over the caul plate **126**, and at **184**, resin exit tubes **122** are placed at each end of the flanges **114** and the web portion **62a** of the charge **62**. At **186**, the inner bag **108** is sealed as shown at **186**. At **188**, an outer bag **130** is installed over the preform charge assembly **62** and sealed to the assembly tool **72**. At **190**, air is evacuated from the inner and outer bags substantially simultaneously, and the preform charge assembly **62** is then infused with resin at **192**. Next, at **194**, the infused charge **62** is cured and at **196** it is removed from the forming tool **72**, trimmed as necessary and cut to the desired lengths.

It may be appreciated that since the inner bag **108** covers the tool **72** during both the assembly and curing stages, the tool **72** may remain substantially free of resin or other residue and may require minimal or no cleaning in preparation for processing of the next part. It may also be appreciated that the inner bag **108** completely envelopes the part and associated disposable materials, thus simplifying transfer to a non clean room type area for trim.

Referring next to FIGS. **26** and **27**, embodiments of the disclosure may be used in the context of an aircraft manufacturing and service method **200** as shown in FIG. **26** and an aircraft **202** as shown in FIG. **27**. During pre-production, exemplary method **200** may include specification and design **204** of the aircraft **202** and material procurement **98**. During production, component and subassembly manufacturing **208** and system integration **210** of the aircraft **202** takes place. During step **208**, the disclosed method and apparatus may be employed to fabricate composite parts such as stiffeners which are then assembled at step **210**. Thereafter, the aircraft **200** may go through certification and delivery **212** in order to be placed in service **214**. While in service by a customer, the aircraft **202** may be scheduled for routine maintenance and service **108** (which may also include modification, reconfiguration, refurbishment, and so on).

Each of the processes of method **200** may be performed or carried out by a system integrator, a third party, and/or an operator (e.g., a customer). For the purposes of this description, a system integrator may include without limitation any number of aircraft manufacturers and major-system subcontractors; a third party may include without limitation any number of vendors, subcontractors, and suppliers; and an operator may be an airline, leasing company, military entity, service organization, and so on.

As shown in FIG. **27**, the aircraft **202** produced by exemplary method **200** may include an airframe **218** with a plurality of systems **220** and an interior **222**. The disclosed method and apparatus may be employed to fabricate stiffeners such as stringers which form part of the airframe **110**. Examples of high-level systems **220** include one or more of a propulsion system **224**, an electrical system **226**, a hydraulic system **228** and an environmental system **230**. Any number of other systems may be included. Although an aerospace example is shown, the principles of the invention may be applied to other industries, such as the automotive industry.

The apparatus embodied herein may be employed during any one or more of the stages of the production and service method **200**. For example, components or subassemblies corresponding to production process **208** may be fabricated or manufactured in a manner similar to components or subassemblies produced while the aircraft **202** is in service. Also, one or more apparatus embodiments may be utilized during the production stages **208** and **210**, for example, by substantially expediting assembly of or reducing the cost of an aircraft **202**. Similarly, one or more apparatus embodiments may be utilized while the aircraft **202** is in service, for example and without limitation, to maintenance and service **216**.

Although the embodiments of this disclosure have been described with respect to certain exemplary embodiments, it is to be understood that the specific embodiments are for purposes of illustration and not limitation, as other variations will occur to those of skill in the art.

What is claimed:

1. Apparatus for making a composite structural member having a web and having at least one contour, comprising:
 - an assembly tool for assembling a plurality of plies forming a charge, wherein the assembly tool comprises:
 - an alignment guide having an adjustable contour against which the plies of the charge may be aligned and contoured; and
 - a spacer adapted to be placed on the charge and having a width substantially equal to a height of the web; and
 - a forming tool for forming the charge, the forming tool including a pair of relatively movable mandrels between which the assembled charge may be clamped.

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2. The apparatus of claim 1, wherein the assembly tool further includes:
 a clamping mechanism for clamping aligned plies together.
3. The apparatus of claim 1, wherein:
 the forming tool includes a substantially vacuum tight base 5
 having pass-throughs adapted to receive for vacuum,
 compressed air and resin lines,
 the mandrels are relatively moveable on the base toward
 and away from each other, and
 the mandrels include tool surfaces over which at least a 10
 portion of the clamped charge may be formed.
4. The apparatus of claim 1, wherein the forming tool includes an inflatable bladder for applying clamping pressure to one of the mandrels.
5. The apparatus of claim 1, further comprising: 15
 a first vacuum bag adapted to cover the formed charge;
 a second vacuum bag adapted to cover the formed charge
 clamped on the forming tool and hold at least a portion of
 the charge against the tool; and
 a resin supply line for introducing resin into the first bag 20
 and infusing the charge.
6. The apparatus of claim 1, wherein each of the mandrels includes a contoured clamping surface for forming a contour into the charge.
7. Apparatus for making a composite member having a web 25
 with a compound contour and at least one flange, comprising:
 an assembly tool for pre-aligning a charge along a first
 contour, the assembly tool further comprising:
 a surface on which a multi-ply charge may be 30
 assembled;
 an alignment guide having an adjustable contour against
 which the plies of the charge may be aligned and
 contoured;
 a spacer adapted to be placed on the charge and having a 35
 width substantially equal to a height of the web portion;
 at least one clamp for clamping aligned and contoured
 plies together with the spacer, and
 grooves to allow clamping access to both sides of the
 charge; and

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- a forming tool including a base and a pair of contoured
 mandrels on the base between which a web portion of the
 charge may be clamped and formed along a second
 contour.
8. The apparatus of claim 7, wherein at least one of the pair
 of contoured mandrels includes a tool surface onto which a
 flange portion of a clamped charge may be formed.
9. Apparatus for making a compound contoured composite
 stringer for aircraft having a web and a flange, comprising:
 an alignment and assembly tool, including—
 a flat surface on which a flat charge may be placed,
 an alignment fence having a first contour corresponding
 to one of the contours of the stringer and against
 which the charge may be aligned,
 a web height spacer for establishing the height of the
 stringer web;
 a plurality of clamps for clamping the charge and adapted to
 abut the web height spacer;
 a forming and cure tool, including—
 a tool base having a first contour which largely matches
 the contour of the alignment fence on the assembly
 tool, the tool base including an assembly of a base
 plate and spaced apart curved blocks,
 a pair of mandrels relatively slideable on the tool base
 toward and away from each other, the mandrels
 including a first set of opposing surfaces having a
 second contour for clamping a web portion of the
 charge therebetween, the mandrels further including a
 second set of tool surfaces onto which a flange portion
 of the charge may be formed;
 a first inner bag covering the formed charge;
 a second bag covering the charge and the first bag;
 first and second seals for sealing the first and second bags
 to the forming and cure tool;
 a resin infusion inlet for allowing resin to flow into the
 charge within the first bag; and
 at least one resin outlet for allowing resin to escape from
 the charge.

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